Work Ordei June-16-14 1:17:	r ID 121071 38 PM		*121	N71*		_				Page 1	1
Revision ID:	O3580-1 Oggle Bracket	D.	Accept	*N900	040	111)* s	etup Sta		S1* S2*	
Start Date: 7 Required Date: 7 Reference:	7/02/14 Start Qty: 30.00 Req'd Qty: 30.00	*30*		Cust Item I Customer:	D:						
Approvals:	Process Plan: MLJ	Date: 14-06-17	Tooling:	Da	nte:		R	kun Sta	<i>"\\</i>	R1*	
;	QC:	Date:	SPC (Y/N):	Da	ite:			Sto	*N	R2*	
Sequence ID/ Work Center ID	Operation Description	·	Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr	Revision Nbr										
D3580	Rev B									_	
100			0.00							DAS 23	
*1 ₀₀ *	FLOW WATER JET						100	D		23 9-89	44625
Waterjet	Memo		0.00	•						,	
FLOW CNC Waterjet	Dwg Rev					,					
110	QC2- Inspect parts off n	nachine FAI/FAIB	0.00							DAG	
*11 0 *				•			1.94	_0		DAS 23	14-06-22
QC Quality Control	Memo		0.00							9-89	_
1				Dae							
*120	QC8- Inspect parts - sec	ond check	0.00 14/6/23	DAS 27 9-89			(100)				
QC	Memo		0.00				Tost				
Quality Control							ء س				

WORK ORDER NON-CONFORMANCE / UPDATE QA Closed: Date: Work Order update only	AEROSPACE
	1, 1
Work Order: DISPOSITION AGAINST DEPARTMENT/PROCESS	
Rework Skid-tube Crosstube Water J	et Engineering
Part No. Scrap Machining Small Fab Prod. Eng. Coc	\vdash \vdash
Use-as-is Thermoforming Finishing Rec/Store/Packagii	<u> </u>
NCR No Suspected Unapproved Large Fab Composite Suppli	- - -
Root Description of work order update Initial Action Sign &	
Cause Date Step Qty or non-conformance Chief Eng Description Date Verification	ion QC Inspector
Design	
Doc/Data Doc/Data	
Equip/Tooling	
Handling/Pre Handling/Pre	
Material	
Operator	
Offset/Setup Offset/Setup	
Process	
Supplier	
Training	
Transport	
Unapproved	
FAULT CATEGORY Landing Gear General	
Landing Gear General Bending Bend Folio/Program Outside Dimensions	Pressure/Forced
Centre Not Concentric BOM/Route Grain Over/Under tolerance	Set-up
Cracks Broken/Damage/Defect Hardware Part Incorrect	Temperature/Cure
Crimp/Kink/Ripple/Wave Burrs Inspection Incomplete/Unqualified Part Lost/Missing	Weld
Cuffs Contamination Instructions Incomplete/Unclear Part Moved	Wrong Stock Pulled
Crushing Countersink Misaligned/off center Positioned Wrong	wrong stock runed
Heat Treat Cut Too Short Mislabeled Power Loss/Surge	Other
Inspection Strip in Tube Drawing Misread	10000
Marks/Chatter Drill Holes Off-set	
Turning Sequence Finish Out of Calibration	
Wave/Twist in Tube Fit/Function Out of Sequence	

Work Orde June-16-14 1:17		21071		*121				Page	2		
Revision ID: Item Name:	D3580-1 Joggle Brack 7/02/14	Start Qty: 30.00 Req'd Qty: 30.00	*:30*	Accept	Cust Item I	040100)* s	etup Star Stop	171	S1* S2*	
Reference:	7/02/14	incq u Qty. 50.00	*30*		Customer:						
Approvals: Process Plan: QC: Sequence ID/ Operation Work Center ID Description 130 *120* Small Fab Memo Small Fab Bend as per		lan:	Date:	Tooling: SPC (Y/N):	Da	R	tun Star Stoj	, "IVI	R1* R2*		
		iwg D3580 using 1/8" off:	Set Up/ Run Hours 0.00 0.00	Tool ID	Tool # Plan Code DAS 30 9-89	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	41	
140 *1 △ ^* QC		QC5- Inspect part comple	eteness to step on W/O	0.00 B 14/071	DAS 27 9-89		(WO))			_

150 .

Identify as per dwg & Stock Location: 57050 0.00

150 Packaging

Quality Control

Memo

0.00

JUL 0 3 2014

Packaging

DQA:		Date	:			*ΔΑΡΤ									
					WORK ORDER NON	-CC	ONFO	RMANCE / U	PDATE				AEROSPACE		
QA Closed:	-	Date	:							W	ork Order u	odate only			
Work Orde	er:				DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS			
					Rework	1		Skid-tube	Crosstube]	Water Jet	Engineering		
Part N	lo.				Scrap	1 1	Machining Small			-	Pro	d. Eng. Coor.	Quality		
	- "				Use-as-is	1	Thermoforming Finish		Finishing		Rec/Store/Packaging		Other		
NCR N	lo				Suspected Unapproved]	Large Fab Composi								
Root	-			Desci	ription of work order update		nitial Action		tion		Sign &				
Cause	Da	te Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription		Date	Verification	QC Inspector		
Design															
Doc/Data				{											
Equip/Tooling						1									
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Material	_														
Operator	_											:			
Offset/Setup		1		ļ		1									
Process				Ì											
Supplier															
Training															
Transport															
Unapproved	<u>L.</u>			İ				<u> </u>			<u> </u>				
						FAI	ULT CAT	EGORY							
Landin	g Gear				General		1 .			_	1	_	۱ ا		
	Bend	-			Bend		1	rogram			Outside Dim	j —	Pressure/Forced		
ŀ	—1	e Not Conce	entric	<u> </u>	BOM/Route		Grain			<u></u>	Over/Under	-	Set-up		
40.	Cracl			-	Broken/Damage/Defect		Hardwa			<u>_</u>	Part Incorred	-	Temperature/Cure		
-	− 1	o/Kink/Rippl	e/Wave		Burrs	\vdash	1	on Incomplete/Ur			Part Lost/Mi	ssing	Weld		
-	Cuffs				Contamination	_	1	ions Incomplete/L	Jnclear	\vdash	Part Moved	L	Wrong Stock Pulled		
-	Crust	_			Countersink	-	-	ned/off center			Positioned V	_	¬		
}		Treat		<u> </u>	Cut Too Short	-	Mislabe			L	Power Loss/	Surge	Other		
}	—	ction Strip ii	1 Tube	<u> </u>	Drawing	-	Misread	1							
}	_	s/Chatter		<u> </u>	Drill Holes	_	Off-set								
}		ng Sequence		<u> </u>	Finish	\vdash	Out of Calibration								
	Wave/Twist in Tube		1	Fit/Function	i	IOut of 9	Sequence								

Work Order ID 121071 *121071* Page 3 June-16-14 1:17:38 PM Item ID: Accept D3580-1 *N900040100* Setup Start **Revision ID:** Stop Item Name: Joggle Bracket *30* 7/02/14 **Start Qty: 30.00** Start Date: **Cust Item ID:** Required Date: 7/02/14 Req'd Qty: 30.00 *30* **Customer:** Reference: Run Start Date: _____ Process Plan: Tooling: Approvals: Date: Stop Date:____ SPC (Y/N): Date: QC: Sequence ID/ Tool ID Operation Set Up/ Reject Reject Tool # Plan Accept Insp. Qty

Work Center ID 160

Description

Run Hours

Code

Qty

Number Stamp

QC21- Final Inspection - Work Order Release

0.00

160

Quality Control

QC :

Memo

0.00

MUS 14-07-07

mf of

DQA:			Date:			_ <u> </u>								TOACT
OA Clasadi			Data			WORK ORDER NON	-C(ONFO	RMANCE / UF		Vanle Ondan			AEROSPACE
QA Closed:			Date:							v	Vork Order u	odate only	Ш	
Work Orde	er:					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS		
!	•					Rework	l		Skid-tube	Crosstube	Water Jet			Engineering
Part N	lo.					Scrap		Machining		Small Fab	Prod. Eng. Coor.		П	Quality
						Use-as-is		Therr	noforming	Finishing	Rec/Store/Packaging		П	Other
NCR N	۱o.					Suspected Unapproved		Large Fab Compos		Composite]	Supplier		
			1								I a: a		 ,	
Root		D-+-	Chara	04	Desc	ription of work order update	l	Initial	Acti		Sign &			
Cause		Date	Step	Qty		or non-conformance	Cn	nief Eng	Descri	iption	Date	Verificatio	<u>n</u>	QC Inspector
Design									;					
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Handling/Pre													ļ	
Material							ŀ						l	
Operator														
Offset/Setup														
Process														
Supplier										•				
Training														
Transport											:			
Unapproved														
							FAI	ULT CA	ΓEGORY					
Landi	ng G	Gear				General		,		_	_		_	•
	-	Bending				Bend		1	Program	<u>_</u>	Outside Dim		—	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route	_	Grain		L	Over/Under		-	Set-up
	_	Cracks				Broken/Damage/Defect	L	Hardwa			Part Incorre		-	Temperature/Cure
	_	Crimp/Kir	nk/Ripple,	/Wave	<u> </u>	Burrs	_	1 '	ion Incomplete/Un	· —	Part Lost/Mi	ssing	Н	Weld
		Cuffs				Contamination		4	tions Incomplete/U	nclear	Part Moved			Wrong Stock Pulled
		Crushing			\vdash	Countersink	$\overline{}$	4 -	gned/off center	<u> </u>	Positioned V			l
	-	Heat Trea			<u> </u>	Cut Too Short	\vdash	Mislabe		L	Power Loss/	Surge		Other
	-	Inspection		Tube	\vdash	Drawing		Misread						
	-	Marks/Ch			-	Drill Holes	<u> </u>	Off-set						
		Turning S			\vdash	Finish	<u> </u>	4	Calibration					
		Wave/Twist in Tube				Fit/Function	ı	Out of S	Sequence					

June-16-14 1:17:37 PM

Work Order ID: 121071

Parent Item:

D3580-1

121071 *D3580-1*

Parent Item Name: Joggle Bracket

Start Date: 7/02/14

Required Date: 7/02/14

Start Qty: 30.00

Required Qty: 30.00

Comments:

IPP Rev : A New Issue 07.06.25 EC

IPP Rev:B Removed Powder Coat 07-07-11 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Stat Issued	us
M304S18GA		Purchased	No		100	sf	516.9100	0.01	0.215789		DAS	
M304S18	RGA							**	e -		23 9-89	(lf-cx-2

304/316 .050 Sheet

Location	Loc Oty	Loc Code	
MAT019	504.91		
117188	3		
117766	5		
120604	5		
122325	3		
123155	3		
124572	38		
M126647	31.55		
M128254	97.71		<u> </u>
M128435	187.25		
M128864	131.4		128064.
MAT020	12		
124029	2		
M126098	10		

DQA:	Date:									TART				
QA Closed:		Date:			WORK ORDER NON-	-C(ONFO	RMANCE / UPDATE	w	ork Order uj	odate only	AEROSPACE		
	·. · · · · · · · · · · · · · · · · · ·						<u> </u>		· · · · · · · · · · · · · · · · · · ·					
Work Orde	r:				DISPOSITION			AGAINS	ST DEPARTMENT/PROCESS					
					Rework		Skid-tube Crosstube				Water Jet	Engineering		
Part N	o				Scrap			Machining Small Fa	b	Pro	d. Eng. Coor.	Quality		
					Use-as-is		Thern	noforming Finishin	g[Rec/Store/Pack		Other		
NCR No.			Suspected Unapproved		Large Fab Composi		e]	Supplier					
Root				Desci	ription of work order update	<u> </u>	nitial Action			Sign &		T		
Cause ^	, Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector		
Design								· · · · · · · · · · · · · · · · · · ·						
Doc/Data														
quip/Tooling														
landling/Pre														
Material					·	ŀ								
Operator														
Offset/Setup		i		•										
rocess														
upplier														
raining														
ransport														
Inapproved		L				<u> </u>				L				
						FAI	ULT CAT	regory						
Landin	g Gear			_	General		1		_	1		- .		
-	Bending	_			Bend	_	1	rogram	<u> </u>	Outside Dim	—	Pressure/Forced		
-	Centre No	ot Concer	ntric	\vdash	BOM/Route	_	Grain		\vdash	Over/Under		Set-up		
-	Cracks			1	Broken/Damage/Defect		Hardwa		<u> </u>	Part Incorre	 -	Temperature/Cure		
-	Crimp/Kir	ık/Ripple	/Wave		Burrs		i i	ion Incomplete/Unqualified	\vdash	Part Lost/Mi	issing	Weld		
-	Cuffs			<u> </u>	Contamination	_	4	ions Incomplete/Unclear	-	Part Moved	∟	Wrong Stock Pulled		
-	Crushing			\vdash	Countersink	_	4	ned/off center	\vdash	Positioned V		J.,,		
-	Heat Trea		T	\vdash	Cut Too Short	<u> </u>	Mislabe			Power Loss/	Surge	Other		
-	Inspection		rupe	 	Drawing		Misread							
}	Marks/Ch			-	Drill Holes	-	Off-set							
}	Turning So			\vdash	Finish	\vdash	4	Calibration						
	Wave/Twist in Tube		l_	Fit/Function	ı	Jour of S	Sequence							

		
DART AEROSPACE LTD	Work Order:	12/07/
DART AEROSPACE LTD		
1. Duncket	Part Number:	D3580-1
Description: Joggle Bracket		
Bow P		Page 1 of 1
Inspection Dwg: D3580 Rev: B		

FIRST ARTICLE INSPECTION CHECKLIST

	X	First Artic	le	Proto	type
Drawing	Tolerance	Actual	Accept	Reject	Method o

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.194	+0.005/-0.001	0.95				Ibmos
1.75	+/-0.030	1.752"			J	
0.75	+/-0.030	6.753	-		1	
0.294	+/-0.010	0.95"			V	
					ļ	
				·		

 DAS
 DAS

 Measured by:
 23 9.89
 Audited by:
 23 27 3.89
 Prototype Approval:

 Date:
 14/06-27
 Date:
 14/6/23
 Date:

				Revised by Approved	1
1	Rev	Date	Change		4
				KJ/EC/DD	
	Α	07 10.30	New Issue		

N/A

N/A

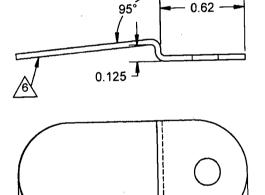


DART AEROSPACE LTD DESIGN DRAWN BY HAWKESBURY, ONTARIO, CANADA LE REV. B DRAWING NO. APPROVED CHECKED SHEET 1 OF 1 D3580 SCALE TITLE DATE JOGGLE BRACKET 07.07.09 DESCRIPTION REV

RELEASED 07.07.09

NEW ISSUE REMOVE POWDER COAT 07.05.15 Α 07.07.09 В 1.75 0.72 0.63 0.294 R0.38 (TYP)

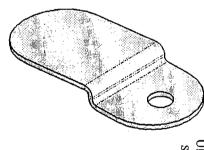
D3580-1F FLAT PATTERN



· 1.68 (REF)

0.75





Ø0.194

BEND ON 0.03 RAD

UNCONTROLLED COPY SUBJECT TO AMENDMENT

RETURN TO

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 18 GAUGE (0.050 THICK) Q
PER MIL-S-5019 (REF DART SPEC M304S18GA)

2) FINISH: NONE

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
6) IDENTIFY WITH DART P/N "D3580-1" USING FINE POINT PERMANENT INK MARKER ON THE UNDERSIDE OF THE PART AS INDICATED

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